



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PC250-400
Job Sheet 179651



Part No: PC250-400

Job Qty: 3 ea

Part Name: Keeper Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/20/18

Job Tracking No:

Due Date: 6/29/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG PC250-400 Rev A IPP Rev A 18.03.01 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Start up Operation	3 Ea	6/29/18	6/29/18	0.00	0.00	Start Up Large Fab-7		EL
110	Large Fab	3 pcs	6/29/18	6/29/18	0.00	3.00	Large Fab 1		EL
120	QC	3 pcs	6/29/18	6/29/18	0.00	0.00	QC9		EL
130	Mill Conv	3 pcs	6/29/18	6/29/18	0.00	1.50	Mill Conv 1		EL
150	QC	3 pcs	6/29/18	6/29/18	0.00	0.00	QC5		EL
160	Packaging	3 pcs	6/29/18	6/29/18	0.00	0.00	Packaging3-2		DAS 21
170	QC21-FG	3 Ea	6/29/18	6/29/18	0.00	0.00	QC21		DAS 21

Part Op 110 - Weld as per DWG. Align holes before welding.
Descriptions: 130 - 1- DRILL HOLE AS PER DWG 2- REMOVE SLOT IN PC250-420 AS PER DWG
160 - Bag and label

OCT 30 2018
OCT 30 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
PC250-420	Inner Keeper	3 Ea (1 ea)	100-Start up Operation	5084452
PC250-430	Outer Keeper	3 Ea (1 ea)	100-Start up Operation	5084454

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Start up Operation	PC250-420	3	9	0
	PC250-430	3	4	0

Part Specifications



Container No: S109418



Part: PC250-400

Job No: 179651

Serial No/Batch: S109418

Revision: a

Inspector:

Exp Date:

Instructions:

Specifications could not be found.

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Plex 6/20/18 1:54 PM Dart.lajeunesse.marie

Date: 09/12/18

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

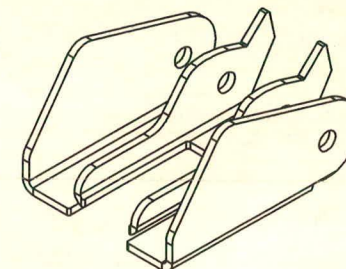
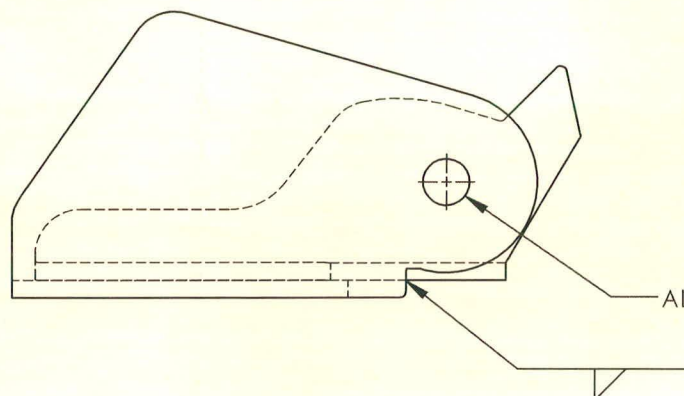
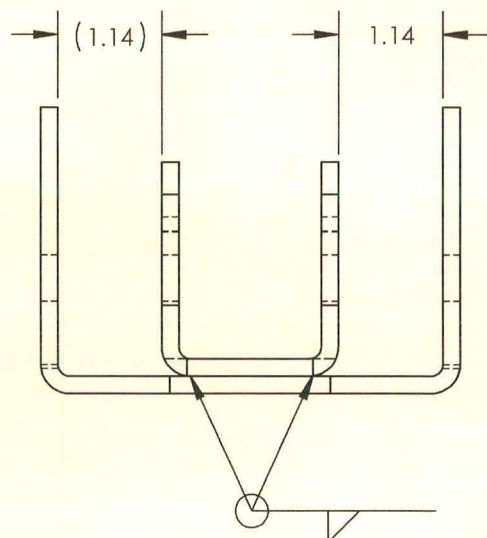
Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____																		

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
		AS DRAWN BY APICAL.	6/12/2013	CFS	
A	14-0129	CH'D TITLE BLOCK WAS RED BARN IS DART. ADDED BAG & LABEL NOTE. CORRECTED TITLE & DWG No ON ALL SHEETS. PC250-420 ADDED MISSING DIMS R.73, 2X R.50, R2.00, 3X R.06. PC250-430 ADDED MISSING DIMS R.50 & R.98.	8/14/2014	DPD	RW



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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 179657 MJS
180620

NOTES:

1. NICKEL PLATE .0004 - .0006, BAKE AFTER PLATING.
2. BAG & LABEL WITH BATCH NUMBER.

DART AEROSPACE	
TITLE KEEPER ASSEMBLY	
DWG NO. PC250-400	REV A
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	DRAWN BY: APICAL APPROVED <i>D Weil</i> HEAT TREAT FINISH SEE NOTE 1 SPEC USED ON MODEL
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:2	DATE 7/8/2004 SHEET 1 OF 3

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			PC250-420	1	INNER KEEPER	1030	3/16 X 6 X 6-1/8	2
			PC250-430	1	OUTER KEEPER	1030	3/16 X 5-3/4 X 10-3/8	3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

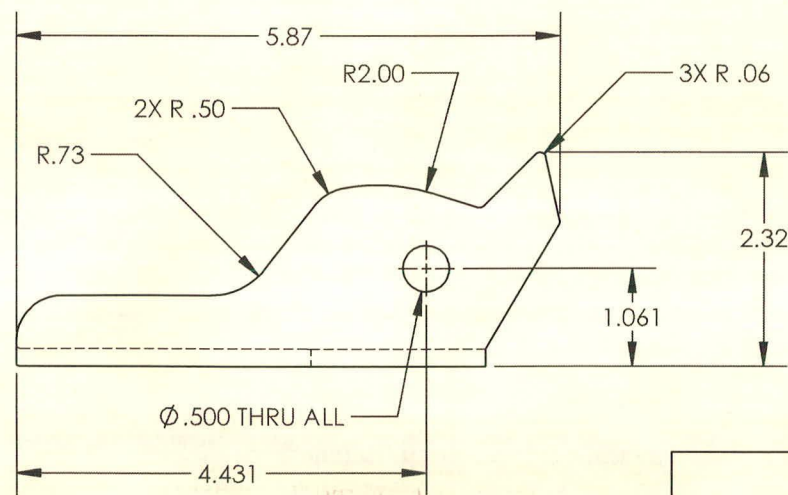
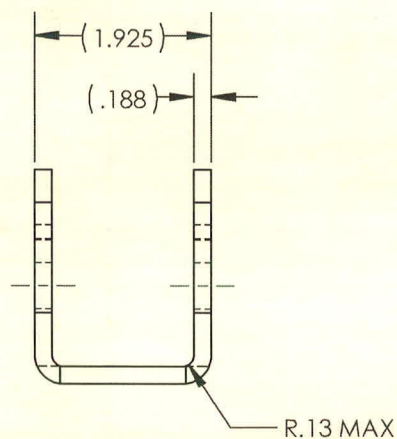
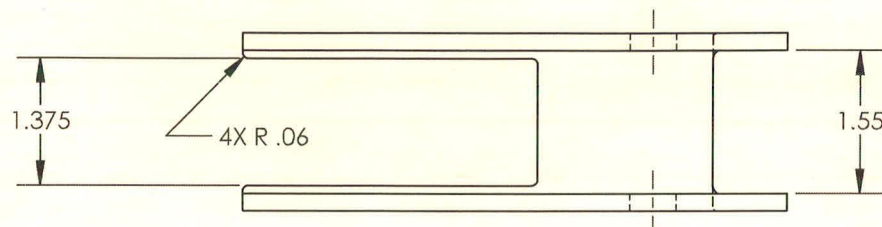
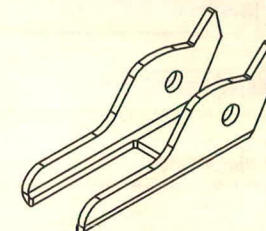
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

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REVISIONS				DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION				
A	14-0129	PC250-420 ADDED MISSING DIMS R.73, 2X R.50, R2.00, 3X R.06.			8/14/2014	DPD RW



PC250-420

INNER KEEPER



TITLE		KEEPER ASSEMBLY	
DWG NO.		PC250-400	
MAT'L 1030		DRAWN BY: APICAL	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		APPROVED <i>D Weil</i>	
.XXX ± .005		HEAT TREAT	
.XX ± .01		FINISH SEE SHEET 1, NOTE 1	
.X ± .1		SPEC	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R		USED ON MODEL	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
SCALE 1:2	DATE 7/8/2004	SHEET 2 OF 3	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

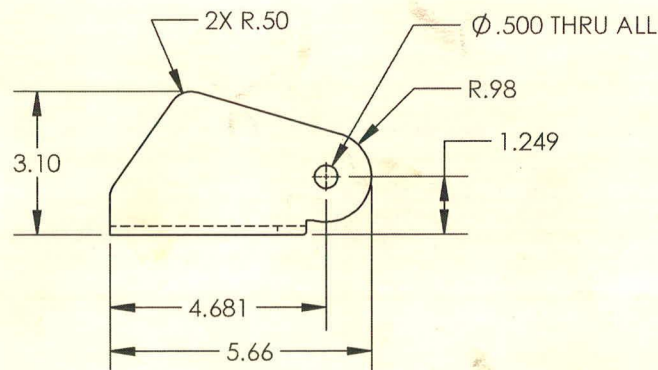
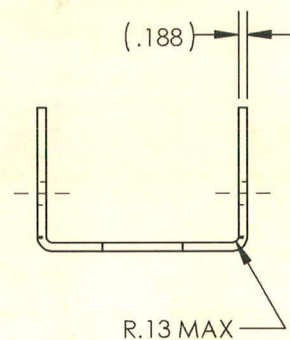
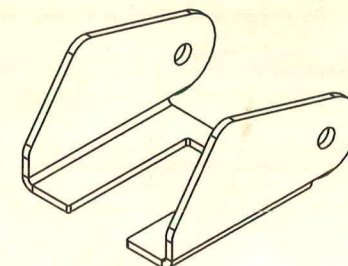
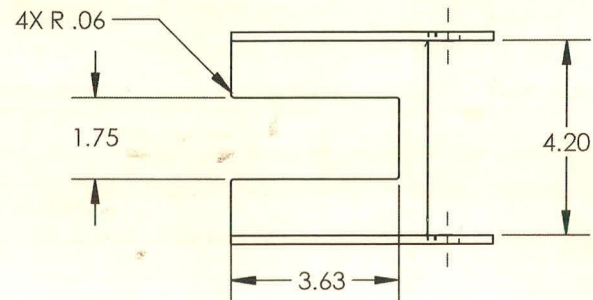
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A	14-0129	PC250-430 ADDED MISSING DIMS R.50 & R.98.			8/14/2014	DPD	RW



PC250-430

OUTER KEEPER

DART AEROSPACE	
TITLE KEEPER ASSEMBLY	
DWG NO. PC250-400	REV A
MAT'L 1030	DRAWN BY: APICAL
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005 FRACTIONS ± 1/8	HEAT TREAT
.XX ± .01 ANGLES ± 5°	FINISH SEE SHEET 1, NOTE 1
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45°	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:4	DATE 7/8/2004
SHEET 3 OF 3	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Description Work Order Deviation				Disposition																					

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						